

# Work Order ID 84804

**\*84804\***

Page 1

May-23-12 11:31:55 AM

Item ID: D2438

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Clamp

Start Date: 23/05/2012 Start Qty: 60.00

**\*60\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 60.00

**\*60\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/23

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2438	Rev C								
100	PURCHASING	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D2438								
<u>304 .063</u>	prog rev: <u>C</u>								
	dwg rev: <u>C</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control	Ensure Material Release Note is attached								
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control	(6.786" center to center)								

60 0 Jm  
12-6-6

60 0 Jm  
12-6-6

59 PTO  
W 12-06-07

W/O: 84804		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2438 PAR #: \_\_\_\_\_ Fault Category: Weld on / etc NCR: Yes No DQA: Not Date: 12/06/28  
 Resolution: \_\_\_\_\_ Disposition: Scrap QA: N/C Closed: ✓ Date: 12/16/29

NCR: 12-1528		WORK ORDER NON-CONFORMANCE (NCR) 6.09						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.06.07	100	1 part scrap, twisted? ground down to much on edge due to de-burring machine. RL operator error	S 12/06/07 astwz	Scrap + Destroy Qty +1	12-16-7	w/ 12.06.07	S 12/06/07 astwz	S 12/06/07

NOTE: Date & initial all entries

Work Order ID **84804**

11:31:55 AM

**\*P24\***

Page 1

Item ID: D2438

Revision ID:

Item Name: Clamp

Start Date: 23/05/2012 Start Qty: 60.00

Required Date: 06/06/2012 Req'd Qty: 60.00

Reference:

**\*60\***

**\*60\***

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject  
Qty Qty Number Insp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

Small Fab

Memo

1- Use DT9713 clamp holder to hold clamp in place when forming  
2- Bend as per dwg using DT9709

0.00

0.00

58

S  
12/06/20

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S12/06/20

counts

(108)

OSP 015

710

150

**\*150\***

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

ST 450

58x

SP  
12-6-21

W/O: 84804		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2438 PAR #: \_\_\_\_\_ Fault Category: under part NCR: Yes No DQA: Auto Date: 12/6/26  
 Resolution: \_\_\_\_\_ Disposition: Scrap QA: N/C Closed: ✓ Date: 12/6/27

NCR: 121529		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/20	130	1 part hole was off set when cut on water jet K.C process	8 ASTHUR 12/6/20	Scrap - distortion no replace	8/5 12/6/20	8 12/6/20	8 ASTHUR 12/6/20	8 12/6/20

NOTE: Date & initial all entries

**Work Order ID 84804****\*84804\***

Page 3

May-23-12 11:31:55 AM

Item ID: D2438

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Clamp

Start Date: 23/05/2012 Start Qty: 60.00

**\*60\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 60.00

**\*60\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/6/22  
MLJ 12106121

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-23-12 11:32:00 AM

Page 1

Work Order ID: 84804

\*84804\*

Parent Item: D2438

\*D2438\*

Parent Item Name: Clamp

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	145.4720	0.04	2.526316			

\*M304S16GA\*

304/316 Sheet .063

\*\*

Location

Loc Qty

Loc Code

MAT020

145.472

121626

145.472

121626

JM  
12-6-6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

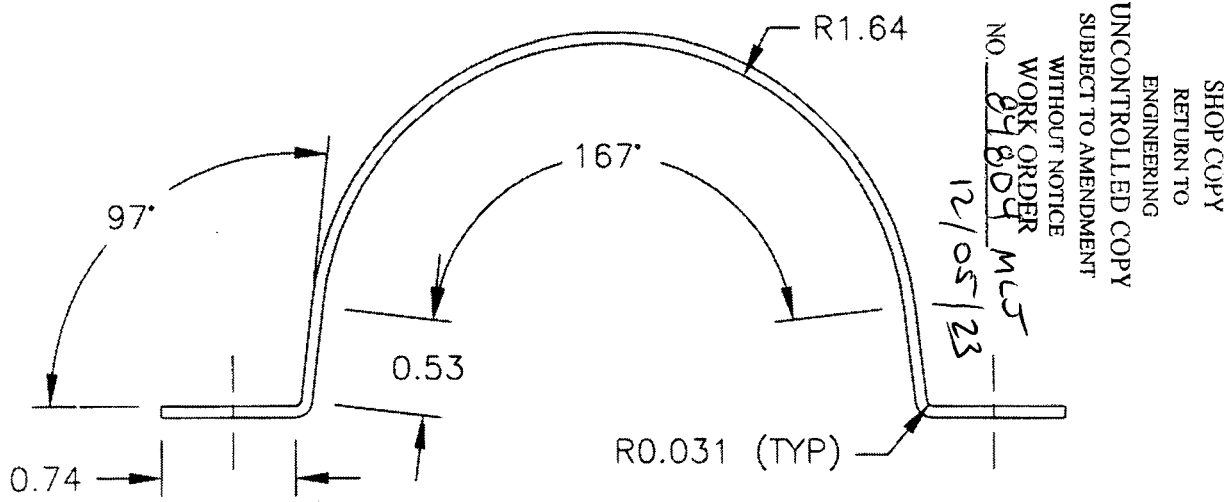
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

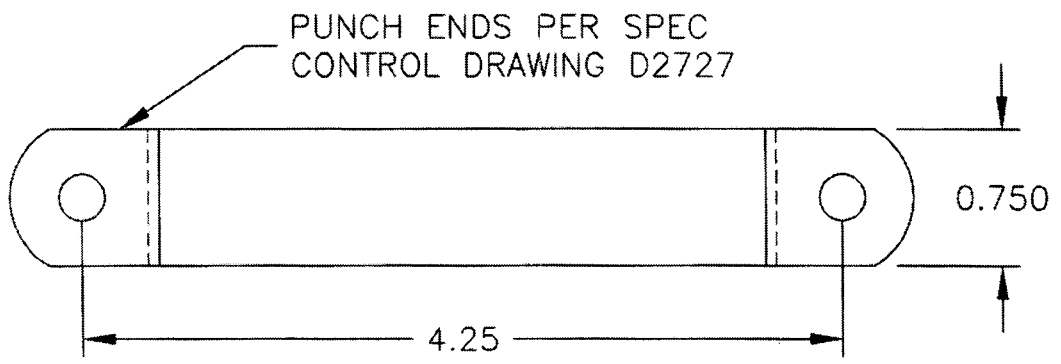


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED  
98.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 87804 MJS  
12/05/23



FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK  
MINIMUM REQUIREMENT IS ANNEALED CONDITION  
# 00.06.06  
CP 00.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries